

Work Order ID 52634

October 5, 2009 10:05:10 AM



Page 1

Item ID: PB67-43001-67

Accept



Setup Start



Revision ID: B1

Stop



Item Name: PB67-43001-67

Start Date: 10/05/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 10/08/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: 09-10-05 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

B67-43001

Rev B1

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg B67-43001-147 ☒ Dwg Rev: *A* ☐ Prog

Rev: ☐ 2-Debuff if necessary

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

mf 09-10-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

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Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Form as per dwg B67-43001

0.00

0.00

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

150



Large Fab

Large Fab

Large Fab

Memo

Weld assembly as per dwg B67-43001

0.00

0.00

Cpl 09 10 07

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Page 3

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

6x

BE 09/09/07

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

2) 8/10/07

6x

180



Small Fab

Small Fab

Small Fab

Memo

Assemble as per dwg B67-43001

0.00

0.00

M-L 09/10/05

6x

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

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Start Date: 10/05/2009 Start Qty: 6.00

Required Date: 10/08/2009 Req'd Qty: 6.00




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo → Powder Coat Part as per Green Sample → QCL Identify as per dwg & Stock Location: <u>437A</u>	0.00 0.00	2) 807/067			(16)	4		
200  Packaging Packaging	Memo	0.00	CPL LOOK 2			9/10/ @ SD			
210  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				09/10/08 HJ 09-10-8			

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Picklist Print

October 5, 2009 10:05:09 AM

Page 1

Work Order ID: 52634

Parent Item: PB67-43001-67RevB1

Parent Item Name: PB67-43001-67

Start Date: 10/05/2009

Required Date: 10/08/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M6061T6S.090

Purchased

No

150

sf

114.8403

3.7541



6061-T6 .090 Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

114.8403

108595

1.41

109184

16.3403

111382

96

19295

1.09

MS20426AD3-4

Purchased

No

100

Each

8,197.000

72.0000



RIVET

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

8197

104374 ✓

4197

110398

4000

m-l 09/10/05

M104374

(72X)

62

PB67-43001-147 x 6. B 52434

10/10/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: PB67-43001-67


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Required Date: 10/08/2009

Comments:

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Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21075L3  Nutplate		Purchased	No			180	Each	167.0000	36.0000			

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	167
109068	12
109371	39
110704	37
111477	2
112640	20
112690 ✓	57

PB67-43001-149RevB1

Manufactured No



Side Plate

180 Each 25.0000 12.0000

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	25
40025	1
41560	24

m-l out 10/05
M112690 (36x)
12

10/09/05

October 5, 2009 10:05:09 AM

Shop Packet Print

Page 2

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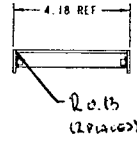
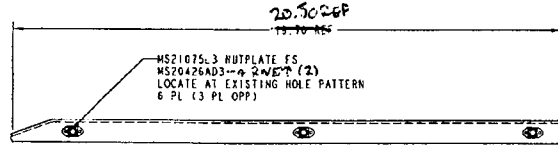
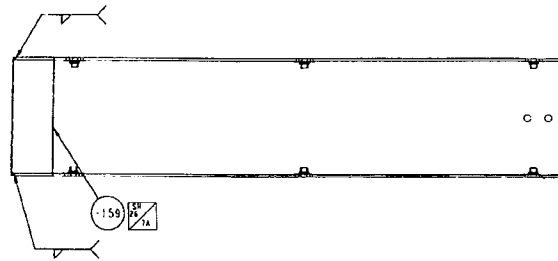
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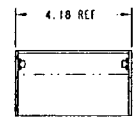
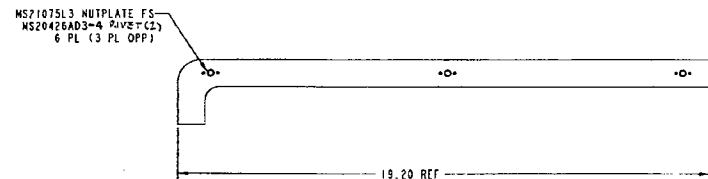
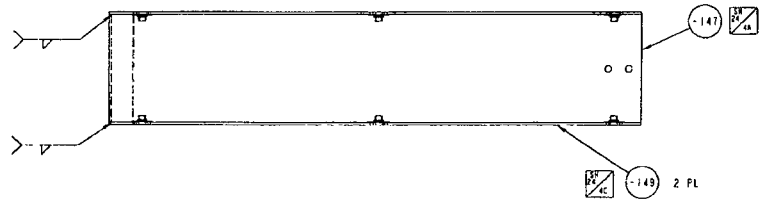
NOTE: Date & initial all entries

32634

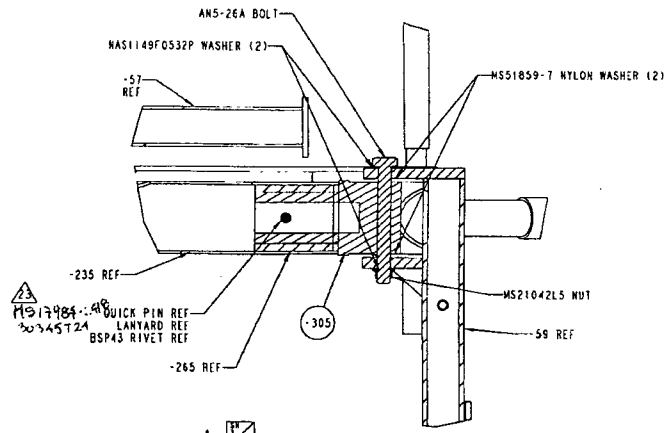
RELEASED
06-01-60



② -71 20 DEGREE BLADE SUPPORT ASSEMBLY
SCALE 0.500



② -67 90 DEGREE BLADE SUPPORT ASSEMBLY
SCALE 0.500



DETAIL A
SCALE 0.750
(-03 ASSY)

PREMIER AVIATION, INC.			
2000 Aviation Parkway, Grand Prairie, Texas 75052			
SIZE	DATE	BY	REV
D	05JVB	867-43001	6
SCALE: 1"=1"		SHEET 5 OF 15	

ORIGINAL

W/O:		WORK ORDER CHANGES					
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